120

\*120\*

Quality Control

QC4-100% Inspect kits for completeness

Memo

		•									DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			i.
											QA Closed	Date	
Work Ord	er					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
Work Ord	٠					Rework	7		Skid-tube	Crosstube	7 .	Water Jet	Engineering
Part I	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1	•	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update	]		Large Fab	Composite	]	Supplier	
								<u> </u>					<u> </u>
Root					Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ct	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													•
Equip/Tooling				İ									
Operator		:											
Material					ŀ								
Setup													
Other			1										
Process							1						
Supplier			1										
Training							ł						
Unapproved													·
						F	AUI	LT CATE	GORY				
Landi	ng (	Gear				General		_			_		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks			Γ	Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld
	Г	Crushed/	Crimned			Burrs		Instruct	ions Incomplete/L	Inclear	Part Lost/M	issing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

\*99937\*

Work Order ID 99937

April-16-13 12:36:07 PM

QC

Quality Control

Item ID: 646.4001 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: AS350 Cable Cutter **Start Date:** 4/16/13 Start Qty: 1.00 \*1\* Cust Item ID: Required Date: 4/30/13 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: Approvals: Date: Tooling: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 130 0.00 Packaging \*130\* Packaging Memo 0.00 Packaging Identify and pack for shipping as per PPP 646,4001 Location: MUS 13-05-30 MK 135-30 140 QC21- Final Inspection - Work Order Release 0.00 \*140\*

0.00

Memo

NCR:	Yes	/	No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

NCK: Y	es / No				WORK ORDER NON-	CON	FURIN	MANCE / OF	DATE	QA Closed:	Date	:
Work Orde	·				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	*
Part N					Rework Scrap	]	1	Skid-tube Machining	Crosstube Small Fab	-	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0		·		Use-as-is Work Order Update	]		oforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update		itial		tion	Sign &		
Cause	Date	Step	Qty	1	or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling										*		
operator Material etup												
)ther	1											
rocess	7											
upplier									•			
raining												
Inapproved												
					F	AULT	CATE	ORY				
Landin	ig Gear				General					_		_
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route	Н	lardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	L lir	nspecti	on Incomplete		Part Incorre	ct _	Weld
	Crushed	/Crimped			Burrs	i	nstructi	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
[	Cuffs				Contamination		Mainte	nance		Part Moved		
Ī	Heat Tre	eat			Countersink		∕Iislabe	led		Positioned V	Vrong	<b>_</b>
1	Inspection	on Strip in	Tube		Cut Too Short		∕lisread			Power Loss/	Surge	Other
	Ripples i	in Bend			Drill Holes		Offset					
	Torque \	Waves in I	Extrusio	n	Drawing		Out of C	Calibration				
-	Turning	Sequence	<b>!</b>		Finish	П	Out of S	equence				
İ		wist in Tu			Teolio	П	Outside	Dimensions	•			

April-16-13 12:36:11 PM

Work Order ID: 199937

Parent Item:

Comments:

646.4001

Parent Item Name: AS350 Cable Cutter

\*99937\*

\*646 4001\*

**Start Date:** 4/16/13

Required Date: 4/30/13

Start Qty: 1.00 Required Qty: 1.00

IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM

Manufactured

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3301		Manufactured	No			••	Each	25.0000					7
*646 3301	k I					•		20.0000	**		(		

0440 5551010 Cupper Gutter Assembly

Λ			Location	<u>1</u>	Loc Qty	Loc Code
5mb			ST139A		7	
9111				125083	7	
			ST545		18	
				93247	18	
	Manufactured	No			Each	17.0000
						**



646.3001

Location	Loc Qty	Loc Code
ST139A	9	
125083	9	
ST537	8	
93425	. 8	
	Each	6.0000



$\wedge$	<u>Location</u>	Loc Oty	Loc Code
( )	ST139A	6	
,	125083	6	

Page 1

											DQA:	Date:	<u>•1</u>	
NCR: Y	es /	/ No				WORK ORDER NON-	COI	VFOR	MANCE / UPD	DATE	OA Clasadi	Data		
						<u> </u>	_				QA Closed:	Date:	•	
Work Orde	ŗ.					DISPOSITION	AGAINST DEPARTMENT/PROCESS							
WOIK OIGE	'' –		<del> </del>		<u>.                                      </u>	Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering	
Part N	0.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
						Use-as-is	]	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR N	lo					Work Order Update			Large Fab	Composite		Supplier		
				T							I 6: 0		1	
Root			C4	0		iption of work order update		Initial	Acti		Sign &	Verification	QC Inspector	
Cause	+	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	ption	Date	verincation	QC Inspector	
oc/Data quip/Tooling	$\dashv$	ļ						ļ					·	
perator	$\dashv$													
/laterial	╡	1												
etup	┨							į						
other	$\exists$													
rocess				المحمد										
upplier														
raining	<u> </u>		•	5										
Inapproved														
						<del></del>	AUL	T CATE	GORY					
Landir r					<u></u>	General	_	1		_	1	<b></b>	<b>1</b>	
1	_	Bending				Bend		Grain		-	Ovalized		Pressure/Forced	
	_	entre No	t Concer	ntric to (	<sup>D/S</sup>  -	BOM/Route	-	Hardwa		-	Over/Under		Temperature/Cure	
}	_	Cracks				Broken/Damaged	-	4	on Incomplete		Part Incorred	<b></b>	Weld Wrong Stock Pulled	
1	_	Crushed/C Cuffs	rimpea		-	Burrs Contamination	$\vdash$	Mainte	ions Incomplete/U	nciear	Part Lost/Mi Part Moved	ssing	wrong Stock Pulled	
}			•		⊢	Countersink	$\vdash$	Mislabe		-	Positioned W	Irong		
-					Cut Too Short	-	Misread			Power Loss/		Other		
	Ripples in Bend Drill Holes						$\vdash$	Offset	•		]. 5446. 25557.			
	Torque Waves in Extrusion Drawing							4	Calibration					
Ì	_	urning Se				Finish		Out of 9	Sequence					
		Wave/Twi		e		Folio		Outside	Dimensions					

April-16-13 12:36:11 PM

Work Order ID: 99937

\*99937\* \*646 4001\*

Parent Item Name: AS350 Cable Cutter

Parent Item:

646.3510

646.3511

646.4001

**Start Date:** 4/16/13

Required Date: 4/30/13

Start Qty: 1.00

Required Qty: 1.00

646.3810 Manufactured Each 8.0000

Location Loc Oty Loc Code ST139A

93300 8 Each

3.0000

Location ST139B

125083

125083

125083

Loc Qty

Loc Code

3 Each 2.0000

Location ST 125023

Location

ST139A

Loc Qty 2

Loc Code

1.0000

646.3512

Location ST139A

Manufactured

Manufactured

Manufactured

Manufactured

Loc Qty

Each

Each

Loc Code

24.0000

646.3513

Loc Oty 24

24

Loc Code

April-16-13 12:36:11 PM

**Shop Packet Print** 

Page 2

												DQA:	Da	ite:	<u>.</u>
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	MANCE / UF	PDATE					
											_	QA Closed:	Da	ite:	·····
Work Ord	er.					DISPOSITION				AGAINST [	ÞΕ	PARTMENT,	/PROCESS		
Work ord	٠	<del></del>			<del></del>	Rework	7		Skid-tube	Crosstube		]	✓ Water Jet	Г	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	_	Pro	d. Eng. Coor.		Quality
	•					Use-as-is	1	Therm	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR I	No.					Work Order Update	]		Large Fab	Composite			Supplier		
							_	<u> </u>							
Root						ption of work order update		Initial		ction		Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	Cr	nief Eng	Des	cription		Date	Verificatio	<u>n</u>	QC Inspector
Doc/Data	Ш														
Equip/Tooling															
Operator	Ш														
Material	Ш														
Setup															
Other															
Process							1								
Supplier	L														
Training															
Unapproved			į		<u> </u>		$\perp$								
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Landi	_	ì				General		,		_		1		_	1 .
		Bending				Bend	$\perp$	Grain				Ovalized		$\vdash$	Pressure/Forced
		Centre N	ot Concer	ntric to (	D/S	BOM/Route	$\perp$	Hardwa				Over/Under	tolerance	<u>L</u>	Temperature/Cure
Cracks						Broken/Damaged	_	-1	on Incomplete	L		Part Incorred		L	Weld
		Crushed/	Crimped		L	Burrs	$\perp$	Instruct	ions Incomplete	/Unclear		Part Lost/Mi	ssing	oxdot	Wrong Stock Pulled
Cuffs						Contamination	L	Mainte	nance			Part Moved	•		
		Heat Trea	at			Countersink	L	Mislabe	led			Positioned V	Vrong	_	,
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i			Power Loss/	Surge	L	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:36:11 PM

Work Order ID: 199937

Parent Item:

NAS1149F0332P

646.4001

Parent Item Name: AS350 Cable Cutter

\*99937\* \*646 4001\*

No

No

**Start Date:** 4/16/13

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

Each 8.710.000

Purchased

Purchased

Location Loc Qty GA 122063 ST294 122063 ST295 123352 st510

123900

158 3 3 8367 8367 Each

182

182

158

4,780.000

Loc Code

MS21042L3



Location Loc Qty FP001 122141 3 GA 119 122452 119 ST314 268 117885 32 119017 55 119075 138 123265 43 ST506 4390 123900 974 124291 3416

Loc Code	

NCR:	Yes	1	No
IACIV.	163	,	INU

DQA: \_\_\_\_\_ Date: \_\_\_\_\_ &

NCR: Ye	es / No				WORK ORDER NON-	CON	<b>FORM</b>	//ANCE / UPI	DATE			•
								-		QA Closed:	Date	:
Work Orde	r:				DISPOSITION		• •		AGAINST D	EPARTMENT	/PROCESS	
Part N	o				Rework Scrap		ľ	Skid-tube Nachining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0			<del></del> .	Use-as-is Work Order Update	_		oforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root	.	<u> </u>		Descr	iption of work order update	In	itial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data												
quip/Tooling											N	
perator											·	
/laterial										İ		
etup										·		
Other												
rocess						1						
upplier	_					-						
raining	_					ł				-		
Inapproved		<u> </u>									<u>.</u>	
					<del></del>	FAULT	CATE	GORY				
Landin	g Gear			_	General				_	_	r	۱ .
	Bending			L	Bend		Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa		L	Over/Under	. —	Temperature/Cure
L	Cracks				Broken/Damaged	-	-	on incomplete	<u> </u>	Part Incorre	<u> </u>	Weld
L	Crushed	Crimped			Burrs		nstruct	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
L	Cuffs			Ŀ	Contamination		Mainte	nance	L	Part Moved		
L	Heat Tre	at		<u></u>	Countersink	Mislabeled Positioned Wrong						_
	Inspection	n Strip in	Tube		Cut Too Short	i	Misreac	l	L	Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes		Offset					<u> </u>
	Torque V	Vaves in I	Extrusio	n [	Drawing		Out of C	Calibration				
[	Turning !	Sequence			Finish		Out of S	equence				
[	Wave/Tv	vist in Tul	be		Folio	Outside Dimensions						

April-16-13 12:36:11 PM

Work Order ID: 99937

\*99937\*

Parent Item:

646.3110

646.4001

\*646 4001\*

Parent Item Name: AS350 Cable Cutter

**Start Date: 4/16/13** Start Qty: 1.00

Required Date: 4/30/13

Required Oty: 1.00

646.3710

646.3210

Manufactured

Manufactured

Manufactured

Manufactured

Location ST139A

Location

Location

Location

ST139A

ST538

ST425

No

125083

97175

93488

Loc Qty 6 6

Each

Each 22.0000

Loc Code

6.0000

Loc Code

22 22

Loc Qty

Each 5.0000

Loc Code

5 5 Each

Loc Qty

7.0000

Loc Code

\*\*

Loc Oty

93208

April-16-13 12:36:11 PM

**Shop Packet Print** 

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											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date	
						<b>T</b>		r			QA Closed.	Date	<del>-</del>
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ord	٠					Rework	7	}	Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	Nο					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		<u>-</u>				Use-as-is	1		noforming	Finishing	<b>⊣</b>	re/Packaging	Other
NCR I	No.					Work Order Update	1	1	Large Fab	Composite	1	Supplier	1
	•					\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	_		- <u>-</u>		<del></del>		
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling			ł	·								:	
Operator							1						
Material													
Setup												:	
Other			-				l						
Process			}										
Supplier													
Training			1									:	
Unapproved			1										
							FAUI	LT CATE	GORY				
Landi	ing (	Gear				General		-1		_	7	_	7
		Bending				Bend		Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
		Centre N	ntre Not Concentric to O/S BOM/Route					Hardwa			Over/Under	<u> </u>	Temperature/Cure
	Cracks Broken/Damaged					Broken/Damaged		<b>-</b> i '	on Incomplete		Part Incorre	<del>-</del>	Weld
	Crushed/Crimped Burrs					Burrs		-1	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs Contamination					Contamination	Maintenance				Part Moved		
	Heat Treat Coun					Countersink	Mislabeled Positioned Wrong				7		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:36:11 PM

Work Order ID: 99937

Parent Item:

MS24694-S51

AN3-13A

AN3-4A

646.4001

Parent Item Name: AS350 Cable Cutter

\*99937\* \*646 4001\*

**Start Date: 4/16/13** 

Start Qty: 1.00

108.0000

Required Date: 4/30/13

Required Qty: 1.00

Purchased

Purchased

No

No

Location ST303 116805 123741

107 Each

108

Loc Oty

Each

95.0000

Loc Code

Loc Code

Purchased No

Location Loc Qty ST351 45 104746 15 120910 30 ST512 50 123759 50 Each

453.0000

Location Loc Qty Loc Code ST350 318 120308 80 122814 38 124858 200 ST512 135 120770 134 123900

											DQA:	Da	te: _	. 6
NCR:	Yes	/ No				WORK ORDER NON-	CON	<b>VFORI</b>	MANCE / UPDATE		QA Closed:	Dai	to:	,
					÷								ie.	•
Nork Ord	er:					DISPOSITION			AGAII	NST DE	PARTMENT	/PROCESS		
Part 1						Rework Scrap Use-as-is		l	Skid-tube Crossto  Machining Small  noforming Finish	Fab	4	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
· NCR I	۷o.					Work Order Update			Large Fab Compo			Supplier		
Root					Descr	iption of work order update	ı	nitial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	<u>1  </u>	QC Inspector
oc/Data	_	:												
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napproved						<del> </del>	<u> </u>							
							AUL	T CATE	GORY					<del>.</del>
Landi	_	1			_	General		1			1	Г		
	<u> </u>	Bending			·.	Bend	$\vdash$	Grain		<u> </u>	Ovalized	,	_	Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric to	O/S	BOM/Route	$\vdash$	Hardwa		<u> </u>	Over/Under	· · · · · · · · · · · · · · · · · · ·		emperature/Cure
	L	Cracks				Broken/Damaged	$\vdash$	1 '	ion Incomplete	<u> </u>	Part Incorred	•		Veld
	<u> </u>	Crushed/	Crimped		<u> </u>	Burrs	-	1	ions Incomplete/Unclear	<u> </u>	Part Lost/Mi	ssing [	\	Wrong Stock Pulled
	<u> </u>	Cuffs			<u> </u>	Contamination	$\vdash$	Mainte		<u> </u>	Part Moved			
	<u> </u>	Heat Trea				Countersink	$\vdash$	Mislabe		<u> </u>	Positioned V	· ·		
	L	Inspection		Tube	<u> </u>	Cut Too Short	$\vdash$	Misread	d		Power Loss/	Surge		Other
	L	Ripples in				Drill Holes	$\vdash$	Offset						
	Ŀ	Torque W		xtrusio	n L	Drawing	$\vdash$	1	Calibration					
		Turning S	equence		1	Finish		Out of S	Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

4pril-16-13 12:36:11 PM

Work Order ID: 199937

646,4001

Parent Item Name: AS350 Cable Cutter

Parent Item:

CR3213-5-3

\*99937\*

\*646 4001\*

**Start Date: 4/16/13** 

Required Date: 4/30/13

Start Qty: 1.00 300.0000

Required Qty: 1.00

MS20470AD5-5.5

Purchased

Manufactured

Manufactured

646.3711

Purchased

No

No

Location ST329

Location

Location

ST139B

ST336

123785

123425

125083

300 Each

300

Loc Oty

Loc Qty

Loc Qty

Each

741.0000

Loc Code

Loc Code

741 741

2

2

2

Each

Each 2.0000

Location Loc Oty Loc Code ST139B

125083

Loc Code

2.0000

NCR:	Yes	/	No

NCR: Ye	es / No				WORK ORDER NON-O	CONF	ORN	MANCE / UP	DATE	QA Closed:	Date	e·
Work Orde	r:				DISPOSITION				AGAINST DE		/PROCESS	
Part No	0				Rework Scrap Use-as-is	-     -       -     -	ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0				Work Order Update	]		Large Fab	Composite	. Recystor	Supplier	
Root				Descri	ption of work order update	Ini	tial	Ac	tion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling	_									1		
Operator												
Material		<u> </u>										
etup												
Other	_					ļ						
rocess											·	}
Supplier		İ				1						
raining		Ì				1						
Jnapproved		<u> </u>								L		_
					F.	AULT	CATE	GORY				
Landin	g Gear				General	_			_	٦	F	_
L	Bending				Bend	$\vdash$	rain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to	o/s	BOM/Route		ardwa			Over/Under	tolerance	Temperature/Cure
L	Cracks				Broken/Damaged	∐In	specti	ion Incomplete		Part Incorre		Weld
	Crushed/	Crimped			Burrs	∐ in	struct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	Шм	/lainte	enance		Part Moved		
	Heat Trea	at			Countersink	M	1islabe	eled		Positioned V	Vrong	_
	Inspection	n Strip in	Tube		Cut Too Short	∐м	1isreac	d .		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		ffset					
. [	Torque W	/aves in E	xtrusio	n [	Drawing		ut of (	Calibration				
	Turning S	equence			Finish		ut of S	Sequence				
	Wave/Tw	ist in Tub	ре	Γ	Folio	Outside Dimensions						

DQA: Date:

April-16-13 12:36:11 PM

Work Order ID: 99937.

646.4001

\*99937\*

Parent Item:

Parent Item Name: AS350 Cable Cutter

\*646 4001\*

646.3811

AN3-6A

MS24694-S55

Manufactured

Each 29.0000

**Start Date:** 4/16/13

Start Qtv: 1.00

Required Date: 4/30/13

Required Qty: 1.00

Purchased

Purchased

Location Loc Qty ST139A 29 125083 9 93224 20 Each Loc Code

438.0000

No

No

Location Loc Qty ST350 300 124296 300 ST351 61 117441 34 121166 13 122993 10 123831 ST512 77 122814 77 Each

Loc Code

92.0000

\*\*

Location Loc Qty Loc Code ST303 92 124296 92

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**Shop Packet Print** 

Page 7

NCR:	Yes	/	No

DQA: \_\_\_\_Date: \_\_\_\_

NCR: Y	es / No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE	QA Close	d: Dat	e:
Work Orde	r:				DISPOSITION				AGAINST	DEPARTMEN	T/PROCESS	
Part N					Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab	Pi	Water Jet od. Eng. Coor.	Engineering Quality
NCR N	o				Use-as-is Work Order Update	1		noforming Large Fab	Finishing Composite	Rec/St	ore/Packaging Supplier	Other
Root		6.			iption of work order update		nitial		tion	Sign &	V. ifi. ii	061
Cause	Date	Step	Qty		or Non-conformance	Cn	ief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling	-											
perator	-											
Material	-											
etup	_											
ther												
rocess										ļ		
upplier												
raining												
Inapproved												
						FAUL	T CATE	GORY				•
Landin	g Gear				General				,		-	
	Bendin	•			Bend		Grain			Ovalized	<b>,</b>	Pressure/Forced
		Not Conce	ntric to	o/s	BOM/Route		Hardwa			—	er tolerance	Temperature/Cure
ļ	Cracks			<u> </u>	Broken/Damaged			on incomplete		Part Incom	l l	Weld
	_	d/Crimped		<u> </u>	Burrs	_	ı	ions Incomplete/(	Unclear	Part Lost/I	- L	Wrong Stock Pulled
	Cuffs				Contamination	<u> </u>	Mainte			Part Move		
Heat Treat Countersink Mislabeled								Positioned	· ·	— <sub>1</sub>		
		ion Strip in	Tube	⊢	Cut Too Short	<u> </u>	Misread	ı		Power Los	s/Surge	Other
1	<b>—</b> ' '	in Bend		<u></u>	Drill Holes	_	Offset					
1		Waves in		n  _	Drawing			Calibration				
		Sequence		<u> </u>	Finish	$\vdash$	i	Sequence				
Wave/Twist in Tube Folio Outside Dimensions												

April-16-13 12:36:11 PM

Work Order ID: 99937

646,4001

\*99937\*

Parent Item Name: AS350 Cable Cutter

Parent Item:

\*646 4001\*

**Start Date: 4/16/13** 

Required Date: 4/30/13

Start Qty: 1.00

\*\*

\*\*

18.0000

Loc Code

Required Oty: 1.00

646.3610

MS20470AD5-6

646.3714

Gusset Bracket

GAe3

Manufactured

Manufactured

Purchased

Manufactured

No

No

No

Location Loc Qty 125083 125083 ST139A 11

93434

93175

105433

124089

93185

Location

ST139A

Location

ST336

Location

ST139B

11 Each 2.0000

Each

Loc Qty

Loc Oty

Loc Qty

9

1756

2 Each 1,756.000

Loc Code

\*\*

Loc Code

866 890 Each

9.0000

Loc Code

\*\*

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**Shop Packet Print** 

Page 8

NCR:	⁄es	/ No				<b>WORK ORDER NON-C</b>		VFOR	MANCE / UPD	ATE			
											QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
	-					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	۱o				<del></del>	Scrap			Machining	Small Fab	1	d. Eng. Coor.	Quality
NCR I	No					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root			!		Descri	ption of work order update	I	nitial	Acti	on	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data	Ц												i
Equip/Tooling	Ш												
Operator	Ш												
Material	Ц												
Setup	Ш	•										•	i .
Other	Ц												
Process	Ц			i									
Supplier	Ц			<b>:</b>									
Training	Ш												
Unapproved			l			<del></del> -	<u>L</u>						
						· · · · · · · · · · · · · · · · · · ·	AUL	T CATE	GORY				
Landi	_					General		1		r	1	_	1
	—	Bending			_	Bend	-	Grain		<u> </u>	Ovalized	_	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	$\vdash$	Hardwa		<u> </u>	Over/Under	· •	Temperature/Cure
		Cracks				Broken/Damaged	-	1 '	on Incomplete	<u> </u>	Part Incorrec	<u> </u>	Weld
	-	Crushed/	Crimped		<u></u>	Burrs		1	ions Incomplete/U	nclear	Part Lost/Mis	ssing	Wrong Stock Pulled
	Ш	Cuffs				Contamination		Mainte		<u> </u>	Part Moved		
	Н	Heat Trea				Countersink	$ldsymbol{le}}}}}}$	Mislabe			Positioned W		1
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/S	Surge	Other
		Ripples in	Bend			Drill Holes	Offset						

Out of Calibration
Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:36:12 PM

Work Order ID:7 "99937: - /

Parent Item:

AN3-3A

646.3813

646,4001

Parent Item Name: AS350 Cable Cutter

\*99937\* \*646 4001\*

Location

123831

124221

124552

ST350

Location

**Start Date: 4/16/13** 

Start Qty: 1.00

Required Date: 4/30/13 Required Qty: 1.00

Manufactured

Strut Bracket

MS20470AD5-7

Rivet

MS21047-3

**NUT PLATE** 

Purchased No

Purchased

Purchased

No

Each 268.0000

Loc Code

5.0000





Location Loc Qty Loc Code ST139d 5 125083 5 Each 2,194.000

Loc Qty

268

200

61

Each

7

Loc Qty Loc Code Mezz 1384 2655 799 3011 585 ST336 810 123425 810 Each 445.0000

\*\*

Location Loc Oty Loc Code ST316 445 123268 75 123301 50 123522 320

April-16-13 12:36:12 PM

**Shop Packet Print** 

Page 9

									DQA:	Date:	•
NCR: Yes	/ No				WORK ORDER NON-C	CONFORI	MANCE / UP	DATE	QA Closed	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			·	Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier											

Landing	Gear	General		_			·
	Bending	Bend		Grain	Ovalized		Pressure/Forced
. [	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance		Temperature/Cure
Γ	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect		Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	L	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved		:
	Heat Treat	Countersink		Mislabeled	Positioned Wrong		_
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	L	Other
. Г	Ripples in Bend	Drill Holes		Offset			
	Torque Waves in Extrusion	Drawing	,	Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			

**FAULT CATEGORY** 

Training Unapproved

April-16-13 12:36:12 PM

Work Order ID: 99937

Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

\*99937\*

\*646 4001\*

**Start Date: 4/16/13** 

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

CCR264SS3-02

Purchased

Purchased

No

Each

740.0000

\*\*

Location

No

ST327

124231 124259

106578

123785

Loc Qty Loc Code 740 100 240 200 200 Each

1,103.000

AN3-5A

Location Loc Qty Loc Code FP001 86 122800 86 GA 120 117423 120 ST350 22 120187 22 ST512 875 122416 75 124561 800

646.3715

Strut Doubler

Manufactured No

> Location Loc Oty ST139B

> > 93338

12

Each

12

Loc Code

12.0000

\*\*

NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			
									QA Closed:	Date:	
Work Orde	n <del>i.</del>				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is	Ther	Skid-tube  Machining  moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo		······································		Work Order Update	i	Large Fab	Composite	J	Supplier	
Root Cause	Date	Step	Qty		ption of work order update	Initial Chief Eng	1	tion ription	Sign & Date	Verification	QC Inspector
Doc/Data	Dute	Jiep	αι,	· · · · · · · · · · · · · · · · · · ·	or won comormance	Cinci Lin	5	. ipa.o.i		70000.0	Qespeete.
Equip/Tooling		l									
Operator		1	,								
Material											
Setup											
Other											
Process											
Supplier											
Training											·
Unapproved		<u> </u>					<u> </u>			<u> </u>	1
					<del></del>	AULT CAT	EGORY				
Landin	ng Gear			_	General	<u> </u>			1	_	1_
}-	Bending				Bend	Grain		-	Ovalized		Pressure/Forced
-	Centre N	ot Conce	ntric to (	D/S	BOM/Route	Hardw		<del> </del>	Over/Under		Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	<b>—</b>	tion Incomplete		Part Incorre	<del></del>	Weld
.	Crushed/	Crimped		<u> </u>	Burrs	<b>—</b> 1	ctions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled
, l	Cuffs			<u> </u>	Contamination	<del></del>	enance	·	Part Moved		
-	Heat Trea			<u> </u>	Countersink	Mislat		<u> </u>	Positioned V	_	اما
.	Inspectio		Tube	_	Cut Too Short	Misrea		L	Power Loss/	Surge	Other
1	Ripples in	n Bend			Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 | 12:36:12 PM

Work Order ID: 99937

\*99937\*

Parent Item:

646.4001

\*646 4001\*

Location

100993

Parent Item Name: AS350 Cable Cutter

**Start Date:** 4/16/13

Required Date: 4/30/13

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-12

646.3716

MS20426AD5-7

MS24694-S54

Purchased

Manufactured

No

Each 169.0000

Mezz

Loc Qty 169 169

Loc Code

4.0000

Purchased

Location 125083

125083

Loc Qty

Each

Loc Code

Each 813.0000

\*\*

Purchased No

Location ' ST334

101340

Loc Oty 813 813

Each

76

75

Loc Code

76.0000

Location Loc Qty ST303 123900 124859

Loc Code

										DQA:	Date:	
NCR: Y	'es /	No			WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
				<del></del>	DISPOSITION				AGAINST DE	· · · · · · · · · · · · · · · · · · ·		
Work Orde	er:					7				1		1
Part N	lo				Rework Scrap Use-as-is		ľ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo			<u></u>	Work Order Update	}		Large Fab	Composite	Nec/3to	Supplier	Other
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	Da	te Ste	p Qty	[ ,	or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
					F	AUI	LT CATE	GORY			- "	
Landir	ng Gear	·			General		<b>-</b>		_	-	<del></del>	<b>-</b>
	Bend Cent	ding re Not Con	centric to	o/s	Bend BOM/Route		Grain Hardwa	re		Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
	Crac	ks			Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crus	hed/Crimp	ed		Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuff	s			Contamination		Mainte	nance		Part Moved		
	Hea	t Treat			Countersink		Mislabe	led		Positioned V	Vrong	<b>-</b>
	insp	ection Strip	in Tube		Cut Too Short		Misreac	I		Power Loss/	Surge	Other
1	Pinn	les in Bend			Drill Holes		Offset		-	_		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:36:12 PM

Work Order ID: 99937

Parent Item:

MS27039-1-21

646.4001

Parent Item Name: AS350 Cable Cutter

\*99937\*

\*646 4001\*

Location

st510

**Start Date: 4/16/13** 

Each

Required Date: 4/30/13

Start Qty: 1.00

Required Qty: 1.00

Purchased

Purchased

No

No

Location Loc Qty ST306 43 115935 43 ST506 300 124326 300

Each

478.0000

343.0000

Loc Code

MS27039-1-19

MS27039-1-20

Purchased

No

478 124326 478 Each

Loc Qty

848.0000

Loc Code

Loc Code

Manufactured No

Location Loc Oty ST306 102 122814 : 2 123522 100 ST506 746 124326 746

2.0000

646.3717

Location ST139B

125083

Loc Qty 2

Each

Loc Code

												DQA:	Da	te:	•-
NCR:	Yes	/ No				WORK ORDER NON-	COI	<b>NFORM</b>	MANCE / UP	DATE					
												QA Closed:	Da	te:	
Work Ord	٥.					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
VVOIKOIA	er.					Rework	7		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part	No.					Scrap	1	Machining Small Fab			┨	Pro	d. Eng. Coor.		Quality
		-				Use-as-is	]	Therm	noforming	Finishing		Rec/Store/Packaging			Other
NCR	No.					Work Order Update			Large Fab	Composite			Supplier	_	
Root			<u> </u>		Descri	tion of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling	匚										Ì		,		
Operator		j							i						
Material	L		Ī												
Setup	<u></u>	[													
Other .	<u></u>										1				
Process											-				
Supplier	<u></u>														
Training							ļ								
Unapproved			<u> </u>												
							AUI	T CATE	GORY						
Land	ing (	1			<del></del>	General		1		Г		la 1: 1		$\overline{}$	]
	$\vdash$	Bending				Bend	<u> </u>	Grain		Ļ	_	Ovalized	1.1	$\vdash$	Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route	-	Hardwa		-	_	Over/Under		$\vdash$	Temperature/Cure
	Cracks					Broken/Damaged	$\vdash$	4	on Incomplete			Part Incorred		-	Weld
1	Crushed/Crimped.					Burrs	$\vdash$	4	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs			_	Contamination	<u> </u>	Mainte		-		Part Moved			
	<u></u>	Heat Trea			<u> </u>	Countersink		Mislabe		-	_	Positioned V	_	_	٦٠٠٠
	Inspection Strip in Tube					Cut Too Short	Misread				Power Loss/Surge		L	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Torque Waves in Extrusion

Turning Sequence ~
Wave/Twist in Tube

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:36:12 PM

Work Order ID: 99937

Parent Item:

646.3718

646,4001

Parent Item Name: AS350 Cable Cutter

\*99937\* \*646 4001\*

**Start Date: 4/16/13** 

Start Qty: 1.00

45.0000

Loc Code

Required Date: 4/30/13

Required Qty: 1.00

646.3719

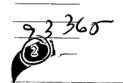
Manufactured

Manufactured No

Location Loc Oty ST139A 125083 ST522 38 93365 38

Each 24.0000

Each



MS27039-1-10

Purchased

No

Location Loc Qty Loc Code ST139B 24 125083 24 Each 321.0000

Location	<u>n</u>	Loc Oty	Loc Code
GA		100	
	120449	100	
ST305		101	
	122815	1	
	124859	100	
ST308		18	
	123522	18	
ST506		102	
	124326	102	

									DQA:	Date:	•
NCR: Yes	/ No				WORK ORDER NON-	CONFOR	MANCE / U	PDATE	QA Closed:	Date:	
Work Order:	·	. M		·	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	<b>⊣ I</b>	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering  Quality  Other
Root				Descri	ption of work order update	Initial	Δ	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Des	scription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup	·	ŀ								٠.	
Other Process Supplier Training Unapproved				÷							
<del>                                     </del>	·	·•	•		F	AULT CATE	GORY				<u> </u>

Landir	anding Gear		General	_	•	_	· ·	
		Bending	Bend	Grain		Ovalized	L	Pressure/Forced
		Centre Not Concentric to O/S	BOM/Route	Hardware		Over/Under tolerance		Temperature/Cure
		Cracks	Broken/Damaged	Inspection Incomplete	L	Part Incorrect		Weld
		Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled
		Cuffs	Contamination	Maintenance		Part Moved		
		Heat Treat	Countersink	Mislabeled		Positioned Wrong		-
		Inspection Strip in Tube	Cut Too Short	Misread		Power Loss/Surge		Other
ſ		Ripples in Bend	Drill Holes	Offset				
Ī		Torque Waves in Extrusion	Drawing	Out of Calibration				
		Turning Sequence	Finish	Out of Sequence				
		Wave/Twist in Tube	Folio	Outside Dimensions				

April-16-13 12:36:12 PM

Work Order ID: 99937

Parent Item:

AN3-11A

646.4001

Parent Item Name: AS350 Cable Cutter

\*99937\* \*646 4001\*

Location

Location

ST

ST

**Start Date: 4/16/13** 

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

<b>L*A</b> N	1:3=1	1-1-1	<b>1</b> %
Bolt			

600.0990

600.0991

Magnabond 6398 Part B (One\_4 oz can)

600.1012

Sealant (One 6 oz Semkit)

Purchased

Purchased

Purchased

Purchased

No

No

No

No

Location Loc Qty Loc Code ST351 72 123525 72 ST512 600 115457 100 200

123352 123759

125051

125051

Each

300

9

9

Each

Each

Loc Oty

Loc Qty

Each

9.0000

Loc Code

Loc Code

672.0000

9.0000

9.0000

Location ST

125051

Loc Oty

Loc Code

									DQA:	Date: _	•
NCR: Ye	es / No				WORK ORDER NON-	CONFORM	MANCE / UF		QA Closed:	Date:	
Work Order					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	Part No.  NCR No.  Root  Descri				Rework Scrap Use-as-is Work Order Update	-	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
	<u> </u>	1		Doscri	ption of work order update	Initial		ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	i	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling										`	
Operator					•	Ì					
Material											
Setup										]	
Other	_										
Process											
Supplier											
Training											
Unapproved			1								

**FAULT CATEGORY** 

Landing (	Gear 🥫		General	_		-	
	Bending		Bend	Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S		BOM/Route	Hardware		Over/Under tolerance	Temperature/Cure
	Cracks		Broken/Damaged	Inspection Incomplete	L	Part Incorrect	Weld
	Crushed/Crimped.		Burrs	Instructions Incomplete/Unclear	L	Part Lost/Missing	Wrong Stock Pulled
	Cuffs		Contamination	Maintenance		Part Moved	
	Heat Treat ~		Countersink	Mislabeled		Positioned Wrong	 _
	Inspection Strip in Tube		Cut Too Short	Misread		Power Loss/Surge	Other
	Ripples in Bend		Drill Holes	Offset			
	Torque Waves in Extrusion	Г	Drawing	Out of Calibration			
	Turning Sequence		Finish T	Out of Sequence			
	Wave/Twist in Tube	Г	Folio	Outside Dimensions			

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

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Work Order ID: 599937

Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

\*99937\* \*646 4001\*

600.0129

600.1013

646.3910

646.3911

Shim

Purchased

Purchased

Manufactured

Manufactured

No

Location

ST 125031

No

Location

Location

ST139B

ST139d

Location

ST139A

ST139d

No

ST139A 125154

125083

93238

125083

945 Each

Loc Oty

Loc Qty

945

128

128

Each

72.0000

Loc Code

128.0000

Loc Code

945.0000

Loc Code

Each 20.0000

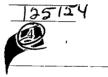
Loc Qty Loc Code

19 93362 19 **Start Date:** 4/16/13

Start Qty: 1.00

Required Qty: 1.00

Required Date: 4/30/13





									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	
Work Order:	• , .				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.	Part No.  NCR No.				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descrip	otion of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	c	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											

**FAULT CATEGORY** 

Landing (	Gear		 • •	_			
	Bending	Bend	Grain	Ovalized		Pressure/Forced	
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance		Temperature/Cure	
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect		Weld	
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled	
	Cuffs	Contamination	Maintenance	Part Moved			
	Heat Treat	Countersink	Mislabeled	Positioned Wrong			
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge		Other	
	Ripples in Bend	Drill Holes	Offset				
	Torque Waves in Extrusion	Drawing	Out of Calibration				
	Turning Sequence	Finish	Out of Sequence				
	Wave/Twist in Tube	Folio	Outside Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:36:12 PM

Work Order ID: 99937

Parent Item:

646.4001

\*99937\* \*646 4001\*

Parent Item Name: AS350 Cable Cutter

646.3912

Manufactured

Each 73.0000

Loc Code

36.0000

Start Qty: 1.00

**Start Date:** 4/16/13

Required Date: 4/30/13

Required Qty: 1.00

Manufactured

646.3913

AN3-12A

5-31.

Purchased No

Location Loc Qty ST139A 22 125083 22 ST139d 51 93423 51 Each

Location Loc Oty ST139B 16 125083 16 ST139d 20 93160 20 Each

Loc Code 59.0000

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Location Loc Qty Loc Code GA 122407 ST351 5 114536 123352 ST512 48 123759 48

123759

									DQA:	Date:	*
NCR: Yes	s / No			WORK ORDER NO	N-CO	NFORM	MANCE / UP		QA Closed:	Date:	
Work Order:			, ,	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.	_				Rework Scrap			Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR No.				Use-as-is Work Order Update		Machining Small Fa Thermoforming Finishin Large Fab Composit			Rec/Store/Packaging Supplier		Other
Doot	T	1		Description of work order updat	- T	Initial	Δι	ction	Sign &	· .	
Root _ Cause	Date	Step	Qty	or Non-conformance	1	nief Eng		cription	Date	Verification	QC Inspector
Doc/Data				-					l		
Equip/ToolingOperator											
Material	]										
Setup Other	_							,			
Process	-		·								
Supplier Training	1									:	
Unapproved	1					LECATE	CORV				
					FAU	LT CATE	GUKY				
Landing	Gear			General							•

Grain Pressure/Forced Ovalized Bend Bending Over/Under tolerance Temperature/Cure BOM/Route Hardware Centre Not Concentric to O/S Weld Inspection Incomplete Broken/Damaged Part Incorrect Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped. Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Other Power Loss/Surge Inspection Strip in Tube **Cut Too Short** Misread Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:36:12 PM

Work Order ID: 99937

Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

\*99937\*

\*646 4001\*

**Start Date: 4/16/13** 

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

MS27039-1-16

Purchased

No

Each

70.0000

Location Loc Qty Loc Code ST306 70 122993 70

									DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Order	··				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.  NCR No.  Root Descr				>	Rework Scrap Use-as-is Work Order Update		Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup									<b>,</b>		
Other											
Process			'								
Supplier											

#### **Landing Gear** General Pressure/Forced Grain Ovalized Bend Bending Over/Under tolerance Temperature/Cure BOM/Route Centre Not Concentric to O/S Hardware Weld Inspection Incomplete Part Incorrect Broken/Damaged Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped. Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Other Power Loss/Surge Inspection Strip in Tube Cut Too Short Misread Offset Drill Holes Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Out of Sequence Finish Outside Dimensions Wave/Twist in Tube Folio

**FAULT CATEGORY** 

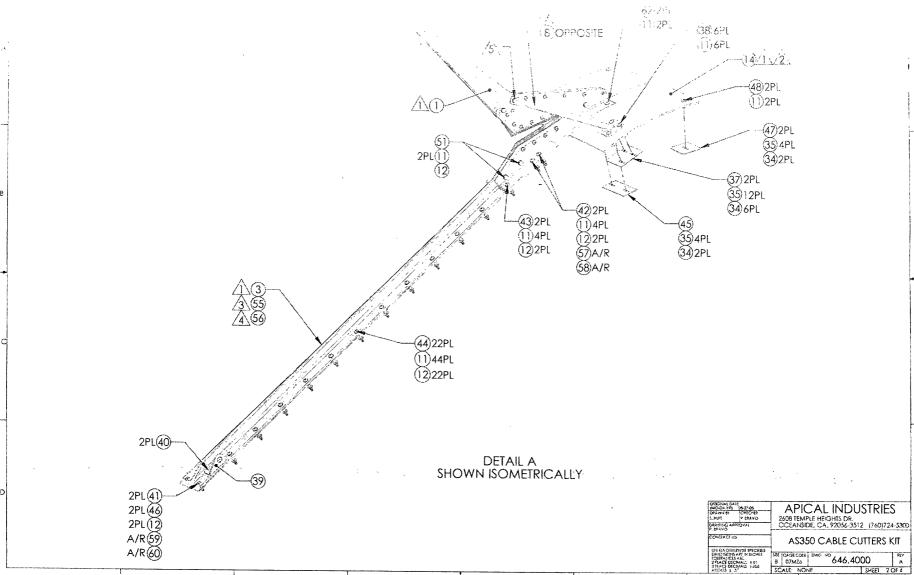
Training Unapproved

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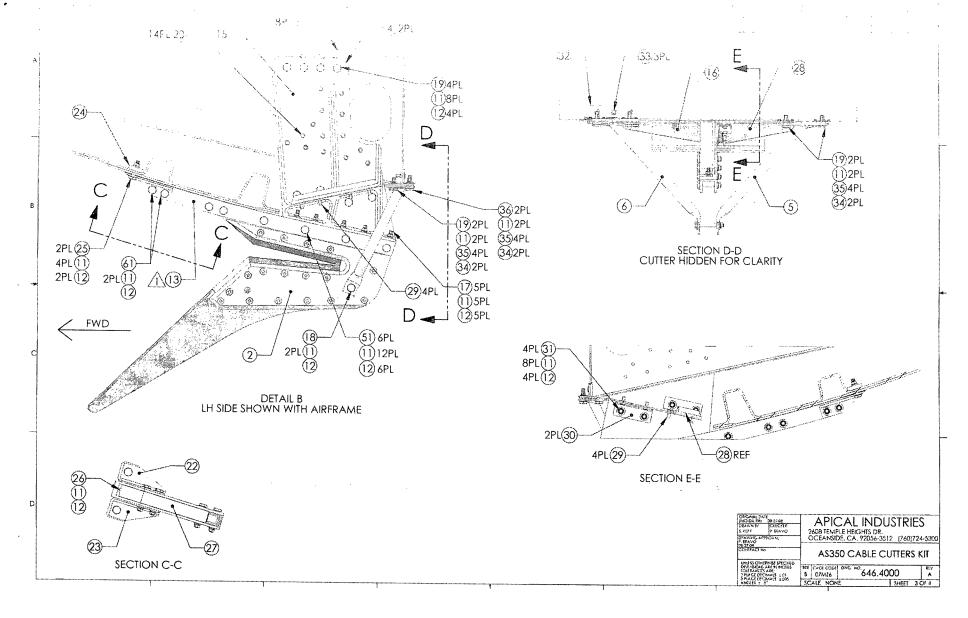
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P. S. September 1975 April 2006	ENGINEERING	CHANGE NOTI	CE NO 0	3079	Marinhar de la contrational accorda contra a company of specific a	SHEE	از 1 ۲	F 1
APICAL	DWG NO. 646	5.4000 RE	V: A PRE	PARED N.CAP	DATE:	03/21/11		DN DWG UNINC.
INDUSTRIES, INC.	DWG TITLE:	AS350 CABLE		**** ·	· · · · · · · · · · · · · · · · · · ·		1 4 1140.	AJ ONTING.
	APPROVED BY, ENGR	PAmo	MFG Davit	2 colo	Discrept	EFF <sup>1</sup>	NEXT OR	DER
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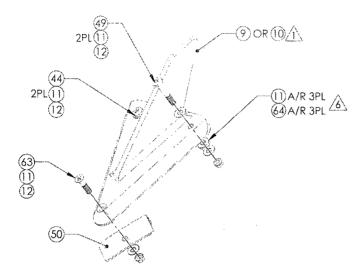
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WAS	03.46, 03074,	÷ o post
A CAFFR INSTALLATION, APPLY FIN 54 A/R TO FILE GAPS AND FILLET EDGES	Caul C3C71	112 (112)
2. INSTALL F/N 14 WITH F/N 52 8 53	1	48 47   1306 (48)   22   25   25   25   25   25   25   2
3M VHB ADHESIVE TAPE 1.025" THICK X 1.50" WIDE VENDOR : MCMASTER-CARR P/N 7.5935A651		(099)   R-12504150 (3181AP11)
	2 55 646 2 49 601 2 2 48 601	.2910 SCREW #587.69
3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE VENDOR: R.S. HUGHES P/N 021200-24216	2 47 646	.1365 SCREW ::552468 :
REUSE FASTENERS FROM F/N 1		.3717 DOUBLER
6 USE WASHERS AS REQUIRED AS SHIMS TO OBTAIN BEST FITMENT		.1952 SCREW (450/659)
	2 41 601	
	2 40 601 1 39 666	1.283) RIVET MS29428A 5.3716 GAUGE BRACKET
	6 38 601	1953 SCREW HISTORY
	2 37 646 2 36 601	
	36 35 601 18 34 603	2277 RIVET CC926/5- 20795 NUIPLATE M52/06/
	3 33 601	1.2565 RIVET M520470A
CONTRACTOR DETAIL A	1 32 646	5.3813 STRUT BRACKET
	4 31 601 2 30 644	1.2822 BOLT ANS-24 5.3812 GUSSET BRACKET
The state of the s		.2564 RIVET MS33479A
	1 27 646	3610 FILLER
→ DETAIL C	1 26 60 2 25 60	
	24 646	5.3811 RADIUS BLOCK
	1 23 646 1 22 646	5.37) 2 CUP 5.37) 1 CUP
	8 21 601	1,2832 RIVET 1000040
	14 20 60	
	10 19 60 1 18 60	1.2827 BOLT ANS-13
c 646.4002	5 17 60	.2912 SCREW M624694
	1 16 640	6.3713 GUSSET 6.3210 SUPPORT
	1 14 640	6.3710 DOUBLER
646.4001	6 63 12 60	6.3110 CHANNEL   MS2104   LOCKNUT   MS2104
	16 34 11 60	1.1607 WASHER MASHER
\DETAIL B	1 10 64	
SET WE D	1 8 64	6.3513 STRUI
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	04 001,3151 VAAGREE 025,124703635 1 5 64	6.3510   STRUT
2	62 601.2637 SCREW MS27039-1-16	6.3810 BRACKET 6.2910 DEPLECTOR
	61 601,2763 BOU ANS 13A 1 2 64	6.3001 LOWER CUTTER ASSY .
		6.3301 UPPER CUTTER ASSY 6.4002 ASSESSMENT DEFLECTOR IOT
	58 646.3911 SHBM 64	6.4001 - ASSLO CABLE QUITERS LEE
D	ND # PART # DESCRIPTION MAPTE SPEC. 400 FIND #	PART # DESCRIPTION MATE
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	S FUEF	P. BRAYO 2608 TEMPLE HEIGHTS DR
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	I	HOSSO CHOLL CO
	UNIESS DAMENTE	DIMENUES SYCOPED SIT   CAGECODS   SWO HO.   646.4   64
		DECMAN 201 6 07MZ6 646.4

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# Work Order ID 99937

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\*99937\*

Item ID: Revision ID:

646.4001

Accept

\*N900040100\*

Setup Start

Item Name:

AS350 Cable Cutter

Start Date: 4/16/13 Required Date: 4/30/13

Start Qty: 1.00 Req'd Qty: 1.00

\*1\*

Cust Item 1D:

**Customer:** 

Reference:

Approvals:

Process Plan:

MLJ

Date: 13-04-16 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID

Operation Description Set Up/ Run Hours

Tool ID

Tool # Plan .Code

Accept Reject Qty Qty

Reject

Insp. Number Stamp

Draw Nbr 646.4000

**Revision Nbr** 

0.00

0.00

MC5 13-04-26

\*100\*

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP 646.4001

110

100

\*110\*

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

120

OC

**Quality Control**